

Date: Wednesday, 29/04/2009 3:01:00 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	205 STEP (EXTENDED HEIGHT)
Job Number :	47597		
Estimate Number :	10182		
P.O. Number :		Part Number :	D205633013
This Issue :	29/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	//	Project Number :	N/A
Previous Run :	25558	Drawing Revision :	N/A
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	05/05/2009
Written By :		Qty:	4 Um: Each
Checked & Approved By :	JUD 09.04.29		
Comment :	Est Rev: F 02.07.11 Reformat; Removed D3010 RF Est rev G 07.08.22 Added hardware per DSI9302-013 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP205-633-013 GH001

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	47597A	STEP WELDMENT
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Comment: Sub-Component STEP WELDMENT

1 x D2563 Batch

4.0	D2021101	Eyebolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2021-101	Eyebolt	40093

5.0	D2022101	Spacer
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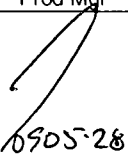
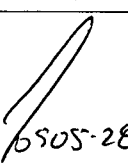


Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2022-101	Spacer	B40093 - B41928

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
090528	1.0	chg is now @ CHG 002, update per NCR09-063				 0905-28	 0905-28	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:01:00 PM
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Job Number: 47597

Part Number: D205633013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022103

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
2 D2022-103 ✓ Spacer

B38329x3 B44353x5 / S09105/15 (u)

7.0

D2562013

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

B38596x3 B36365x1 / S09105/15 (u)

8.0

D2565201

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
1 D2565-201 ✓ Strut

B36514x3 B36366x1 / S09105/15 (u)

9.0

D2565203

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
1 D2565-203 ✓ Strut

36513 / S09105/15 (u)

10.0

D2565205

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
1 D2565-205 ✓ Strut

36515 / S09105/15 (u)

11.0

D2565207

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
1 D2565-207 ✓ Strut

36516 / S09105/15 (u)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:01:00 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP (EXTENDED HEIGHT)

Job Number: 47597

Part Number: D205633013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2565209

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-209 Strut

B336517x3 B37392x1 SS 09/05/15 (X4)

13.0

D2565211

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-211 Strut

B338088 SS 09/05/15 (X4)

14.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

(2) AN4-5A Bolt

M109001 + 4/09/15/25 SS 09/05/15 (X4)

15.0

AN46A

Bolt



Comment: Qty.: 3 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

3/2 AN4-6A Bolt

M110399 + 8 / 04/05/29 SS 09/05/15 (X4)

16.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-7A Bolt

M110155 SS 09/05/15 (X4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:01:00 PM
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 47597

Part Number: D205633013

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN414A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4-14A ✓ Bolt M167534

SS 09/05/15 (X4)

18.0

AN514A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN5-14A ✓ Bolt M169262

SS 09/05/15 (X4)

19.0

AN44 7A ✓

EYEBOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

EYEBOLT

M108638 9/5/13

SS 09/05/15 (X4)

20.0

AN960JD416

Washer



Comment: Qty.: 17.0000 Each(s)/Unit Total: 68.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

15 AN960JD416 Washer M110363

16

9/5/13 (-9/10/15/28)

Qty 16 per DC09-063
20505-28

21.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 ✓ Washer M110523

9/5/13

(X4)

sf

DSI 9302

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 STEP (EXTENDED HEIGHT)

Job Number: 47597

Part Number: D205633013

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

MS21042L4

Nut

8 (4)



Qty 8 per D205-633
20905-28

Comment: Qty.: 8.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut M110450

9/5/13

(-4) 9/5/13

SP

23.0

MS21042L5

Nut

5 (4)



Qty 2 per D205-633

209-05-28



(4)

Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5 Nut M109840

9/5/13

(-4) 9/5/13

SP

24.0

D2563

Step Weldment Assembly



(PTU)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2563 Step Weldment

N/A

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

809662 809662 (4)

26.0

PACKAGING 1

PACKAGING RESOURCE #1



(4)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-013

Location: 20

Der H 9/6/13

SP

27.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



AN410A x 1 each - (4 total)
M16 8986
See PTU on 24.0
9/6/13

Dart Aerospace Ltd

W/O: 47597		EST: 10182		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
0905-28	24.0	D2563 is already on the W/O @ 3.0 Remove @ 24.0. Add in the correct location, Qty 1 AUY-10A Bolt. See NCR below.	E	09.06.03		0905-28	0905-28	

Part No: D205-633-013 PAR #: N/A Fault Category: Production Coordination NCR: (Yes) No DQA: D Date: 09/06/04
 Resolution: DCA Umentation sense Disposition: re-work QA: N/C Closed Date: 09/06/04

NCR: 47597		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0905-28	1.0 25.0	open investigating the CHG #, that is now at CHG 002, incorrect Qty's, & a missing bolt was noticed. R.C: L.O.A.	0905-28	NCR 09-063 was created to update & correct the I.P.P.	0905-28	09/05/04	0905-28	0905-28

NOTE: Date & initial all entries

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	4	4	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: B

Date: 07.08.21